

Date: Monday, 15/12/2008 10:12:55 AM  
User: Linda Lacelle

## **Process Sheet**

|                                  |   |                 |   |                         |                  |     |  |
|----------------------------------|---|-----------------|---|-------------------------|------------------|-----|--|
| <b>Customer</b>                  | : CU-DAR001 Dart Helicopters Services       |                 |   | <b>Drawing Name</b>     | : TUBE           |     |  |
| <b>Job Number</b>                | : 44080                                     |                 |   |                         |                  |     |  |
| <b>Estimate Number</b>           | : 11175                                     |                 |   |                         |                  |     |  |
| <b>P.O. Number</b>               | :   |                 |   | <b>Part Number</b>      | : D22825         |     |  |
| <b>This Issue</b>                | : 15/12/2008                                | <b>S.O. No.</b> | : | <b>Drawing Number</b>   | : D2282 REV E    |     |  |
| <b>Prsht Rev.</b>                | : NC  |                 |   | <b>Project Number</b>   | : N/A            |     |  |
| <b>First Issue</b>               | : / /                                       |                 |   | <b>Type</b>             | : MACHINED PARTS |     |  |
| <b>Previous Run</b>              | : 43743                                     |                 |   | <b>Drawing Revision</b> | : E              |     |  |
| <b>Written By</b>                | :   |                 |   | <b>Material</b>         | :                |     |  |
| <b>Checked &amp; Approved By</b> | :   |                 |   | <b>Due Date</b>         | : 05/01/2009     |     |  |
| <b>Comment</b>                   | : Est Rev:A<br>: EstRev:B<br>Verified By:EC |                 |   | Removed from 9 Digit    | 05-12-02         | JLM |  |
|                                  |   |                 |   | Now on Doosan Lathe     | 08-06-05         | JLM |  |

## **Additional Product**

Job Number:



| Seq. #: | Machine Or Operation:   | Description :   |
|---------|---|---|
| 1.0     | M304R0750   | 304 SS Roundbar .750<br>                     |
|         | Comment: Qty.: 0.1891 f(s)/Unit Total : 11.3438 f(s)<br>Material: AISI 304 Stainless Steel Ø0.750(M304R0.750)<br>Batch <u>M110166</u> | <br>DA 08/12/21                            |
| 2.0     | DOOSAN LATHE  | DOOSAN LATHE<br>                           |
|         | Comment: DOOSAN LATHE<br>1-Turn as per Dwg D2282 and Folio FA189  |    |
|         | 2-Deburr  | <br>DA 08/12/21 60                         |
| 3.0     | QC2   | INSPECT PARTS AS THEY COME OFF MACHINE<br> |
|         | Comment: INSPECT PARTS AS THEY COME OFF MACHINE   | <br>DA 08/12/21 60                       |
| 4.0     | QC8   | SECOND CHECK<br>                           |
|         | Comment: SECOND CHECK   | <br>DA 08/12/22 60                       |
| 5.0     | PACKAGING 1   | PACKAGING RESOURCE #1<br>                  |
|         | Comment: PACKAGING RESOURCE #1<br>Identify and Stock<br>Location: <u>S725</u>   | <br>SS 08/12/22 X00                      |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

Date: Monday, 15/12/2008 10:12:55 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 44080

Part Number: D22825

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/22 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 8.12.22

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

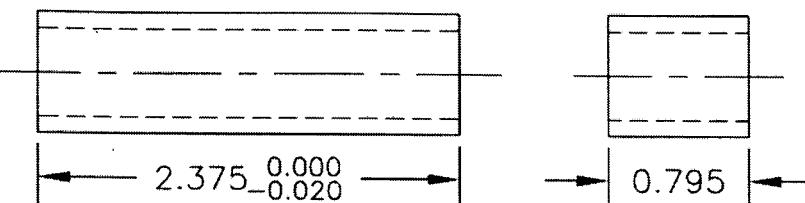
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

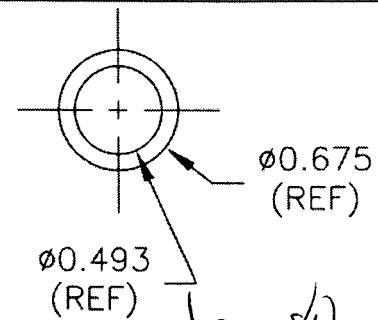
**DART**

|                              |                                |   |                        |
|------------------------------|--------------------------------|---|------------------------|
| DESIGN<br>BW                 | DRAWN BY<br><i>[Signature]</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA               |                        |
| CHECKED<br><i>[Initials]</i> | APPROVED<br><i>[Initials]</i>  | DRAWING NO.<br>D2282  | REV. E<br>SHEET 1 OF 2 |
| DATE<br>05.06.07             |                                | TITLE<br>HANDLE TUBES   | SCALE<br>1:1           |
| A                            | 94.10.14                       | NEW ISSUE   |                        |
| B                            | 95.03.23                       | RE-DESIGN   |                        |
| C                            | 97.10.20                       | CORRECTED NUMBERING SCHEME                                      |                        |
| D                            | 05.03.16                       | REDESIGN D2282-5; 0.795 WAS 0.750                               |                        |
| E                            | 05.06.07                       | D2282-5 304 SS WAS 303 SS;<br>R0.063 x 0.063 WAS R0.080 x 0.030 |                        |

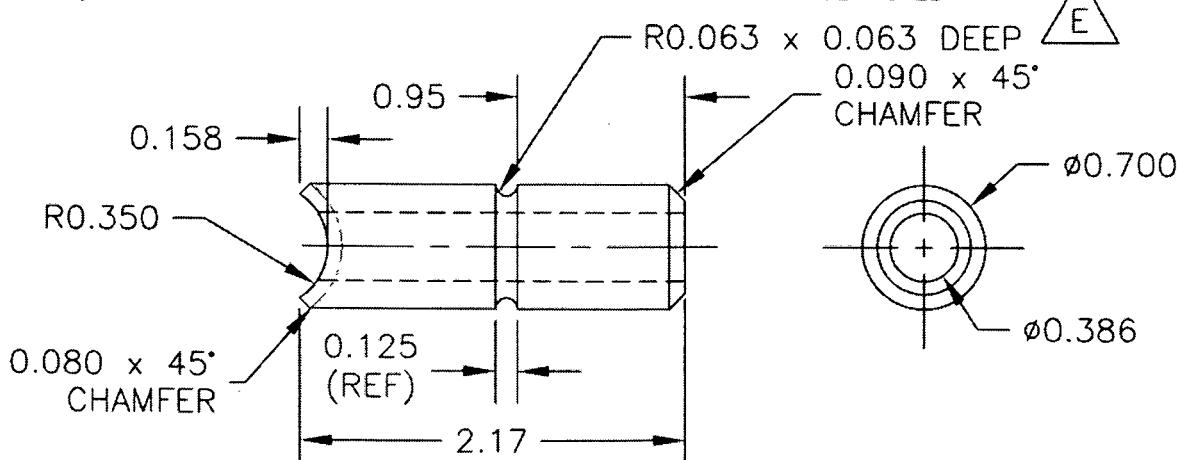
**RELEASED**  
*BS/09/16*

D2282-3

D

D2282-7*w/o 0.040*D2282-3/-7 TUBE:

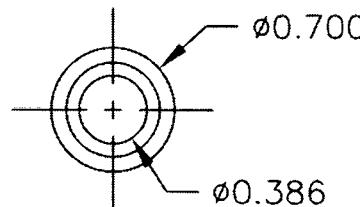
- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D

D2282-5

E

D2282-5 STEM:

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

E

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

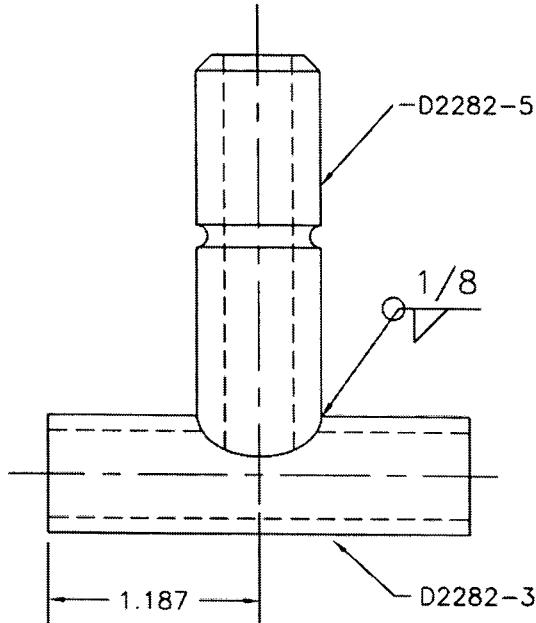
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

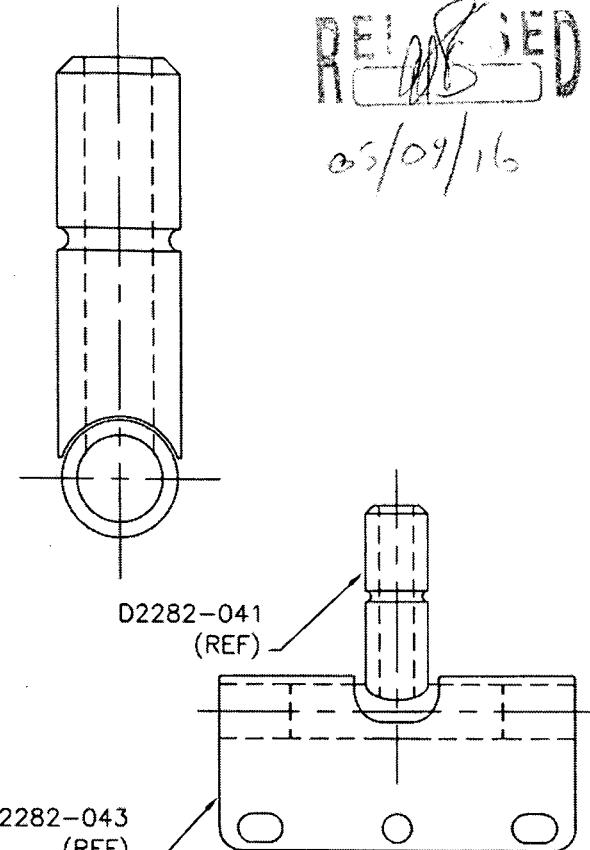
NOTE: Date & initial all entries

**DART**

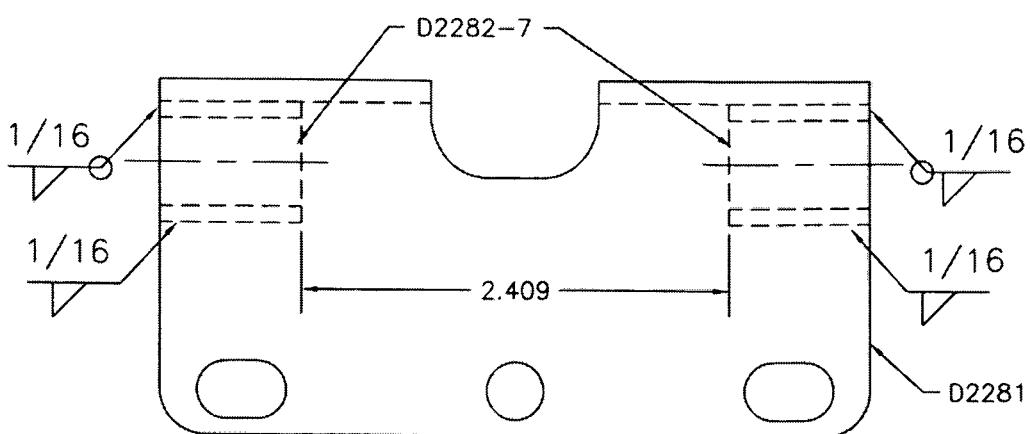
|                      |                                |   |
|----------------------|--------------------------------|---|
| DESIGN<br>BW         | DRAWN BY<br><i>[Signature]</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA               |
| CHECKED<br><i>IP</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2282  |
| DATE<br>05.06.07     |                                | REV. E<br>SHEET 2 OF 2<br>TITLE<br>HANDLE TUBES<br>SCALE<br>1:1 |



D2282-041 'T' ASSEMBLY  
WELD ASSEMBLY PER DART QSI 004



GENERAL ASSEMBLY  
SCALE 1:2



D2282-043 SADDLE ASSEMBLY  
WELD ASSEMBLY PER DART QSI 004

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

|                           |              |             |
|---------------------------|--------------|-------------|
| DART AEROSPACE LTD        | Work Order:  | 44080       |
| Description: HANDLE TUBOS | Part Number: | D2282-5     |
| Inspection Dwg:           | Rev: E       | Page 1 of 1 |

# **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

|                     |          |
|---------------------|----------|
| <b>Measured by:</b> | SJ       |
| <b>Date:</b>        | 08/12/21 |

|             |           |
|-------------|-----------|
| Audited by: | <i>mk</i> |
| Date:       | 08/12/22  |

|                            |     |
|----------------------------|-----|
| <b>Prototype Approval:</b> | N/A |
| <b>Date:</b>               | N/A |

| <b>Rev</b> | <b>Date</b> | <b>Change</b> | <b>Revised by</b> | <b>Approved</b> |
|------------|-------------|---------------|-------------------|-----------------|
| A          | .           | New Issue     | KJ/JLM            |                 |

 68